

Work Order ID 82728

82728

Page 1

April-05-12 12:54:28 PM

Item ID: D407-667-105

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Fwd

Stop

NS2

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D407-667-145

Rev C (DEQ)

DSI9565

A

KSP

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D407-667-105 CHG004

S. 7/12/15

MLJ 12-5-15

110

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

JW

12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82728

82728

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Item ID: D407-667-105

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N9000040100

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NS1

Revision ID:

Item Name: Crosstube Fwd

Stop

NS2

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00

120

BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw

JW/KM

12-04-26

130

QC15- Crosstube Dimensional Check

0.00

130

QC

Memo

0.00

Quality Control

Sizlutz

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 82728***82728***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Fwd

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Crosstubes

0.00

Crosstubes

Memo

Crosstubes

1- scribe batch # inside of cuff

2-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes use drill table jig DT8577 hole #1,#11 to set up towers, as per QSI0010.

3-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145 Check dimensions between holes on all four sides.

4-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

5-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

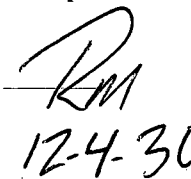
6-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145

7-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145.Note: Fwd side has 3x top holes.

8-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

9-C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint.

10 -Deburr & Inspect for surface damage. Repair damage within limits as per



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

Item Name: Crosstube Fwd

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Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Dwg D407-667-145

150

Crosstubes Chemical Conversion

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Rm
12-5-1

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

5/7/12/13

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

5/7/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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12/205-4

1x 50

12-5-4

12. 05. 04 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 82728

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April-05-12 12:54:28 PM

Item ID: D407-667-105

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Fwd

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00

210

SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME: 121334

Start Time: 6:30

Finish Time: 7:15

PAINT: 120985

Start Time: 11:15

Finish Time: 12:00

★ CLEAR COAT
PER ATTACHED
INSTRUCTION (P. 12.05.04)

Clear 121625
Start: 4:45
Finish: 5:30

12-5-5

220

QC14- Inspect Spray Paint

0.00

220

QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

12.05.06 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 82728

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Item ID: D407-667-105 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Fwd
 Start Date: 05/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 26/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe								
	2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: <u>121287</u>								
	3- Torque bolts as per dwg								
	4-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

12-5-6

12-05-09 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 8

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 Item Name: Crosstube Fwd
 Start Date: 05/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 26/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				IX			SP
Packaging									12-5-15.
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							5/7/15
Quality Control									
270		0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D407-667-105								
	Location: <u>53</u>								
	PPP Rev: <u>53</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-05-12 12:54:28 PM

Item ID: D407-667-105 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Crosstube Fwd
 Start Date: 05/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 26/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/5/16 
 MLC 12/05/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-05-12 12:54:33 PM

Page 1

Work Order ID: 82728

82728

Parent Item: D407-667-105

D407-667-105

Parent Item Name: Crosstube Fwd

Start Date: 05/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:F 05.09.01 Add holes for compatibility with Bell SkidtubesKJ/JLM
 IPP Rev:G 08-05-16 chg QC6 to QC15 DD verified by:EC
 IPP Rev:H 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
 IPP Rev:I 08-07-14 add (scribe inside of tube) seq.6 DD verified by:EC
 IPP Rev:J 08-07-28 update as per (par 08-013) DD verified by:EC
 IPP Rev K 09.01.06 ECN 08-562 EC verified by:DD IPP REV:L
 11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D407-667-105TRN		Manufactured	No	B81525		110	Each	0.0000	1	1	①	Rm 12-4-26	
D407-667-105TRN									**				
Crosstube Turning Detail													
D2873-043		Manufactured	No			230	Each	8.0000	2	2			
D2873-043									**			AP 12-5-6	
Nut Plate Assembly											②		
				Location		Loc Qty							
				LG052		8							
				72644		2							
				80228		6							
D2873-045		Manufactured	No			230	Each	1.0000	2	2			
D2873-045									**			AP 12-5-6	
Nut Plate Assembly											②		
				Location		Loc Qty							
				LG052		1							
				80162		1							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D407-667-105

D407-667-105

Parent Item Name: Crosstube Fwd

Start Date: 05/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2891-1 Manufactured No

230

Each

20.0000

2

2

D2891-1

**

A8 12-5-6

2.25 Support

Location

82277

Loc Qty

Loc Code

(2)

LG052

20

72822

1

75176

1

80160

18

D3595-063-395

Manufactured No

230

Each

94.0000

4

4

D3595-063-395

**

A8 12-5-6

RUBBER CUSHION

Location

Loc Qty

Loc Code

LG051

94

82223

94

(4)

MS20601-AD4W10

Purchased No

230

Each

188.0000

14

14

MS20601-AD4W10

**

A8 12-5-6

RIVET

Location

Loc Qty

Loc Code

LG050

187

120676

87

125125

100

(14)

LG051

1

118675

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D407-667-105

D407-667-105

Parent Item Name: Crosstube Fwd

Start Date: 05/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

230

Each

152.0000

4

4

MS21920-20

Clamp (per MIL-DTL-8783C)

**

12-5-6

Location

Loc Qty

Loc Code

LG050

152

116799

8

120676

44

121067

50

121274

50

AN5-10A

Purchased

No

250

Each

452.0000

10

10

AN5-10A

Bolt

**

Location

Loc Qty

Loc Code

ST337

452

118191

80

120630

30

120717

50

120770

142

121181

50

121243

100

AN5-30A

Purchased

No

250

Each

125.0000

4

4

AN5-30A

BOLT

**

Location

Loc Qty

Loc Code

ST339

125

117514

7

120423

63

120910

25

121259

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D407-667-105

D407-667-105

Parent Item Name: Crosstube Fwd

Start Date: 05/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-32A

Purchased

No

250

Each

224.0000

4

4

AN5-32A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST339

224

119328

69

119862

50

120423

75

120910

30

4x 5 in

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

18

18

AN960JD516

Washer

**

M119546 SP - 8 in

MS21042L5

Purchased

No

250

Each

1,453.000

4

4

MS21042L5

Nut

**

SP 12-5-15

Location

Loc Qty

Loc Code

ST300

1453

116105

5

116548

43

117611

42

119109

1363

4x 5 in

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D206-667 Rev. 3 OR LATER

REF. CANADIAN STC: SH01-5

REF. FAA STC: SR01304NY

REF. EASA STC: EASA.IM.R.S.01179

PURPOSE:

The supports on the following crosstubes are now installed using Proseal instead of Magnobond:

D206-667-101 @ CHG 004
D206-667-103 @ CHG 005
D206-667-107 @ CHG 002
D206-667-201 @ CHG 004

D206-667-203 @ CHG 004
D206-667-207 @ CHG 002
D407-667-105 @ CHG 004

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 823228
12/04/05
MCS

CHANGE:

For the crosstubes listed above, section 32.4 of ICA-D206-667 is amended as follows. Use Figures 32-4 to 32-8 of ICA-D206-667 for further reference. For crosstubes of an earlier change number, it is recommended that if the supports are removed, the supports should be reinstalled using the procedure listed below.





32.4 SUPPORT INSTALLATION

- 32.4.1 Locate the area on crosstube for installation of support (ref. Figures 32-4 to 32-8 of ICA-D206-667). For D206-667-101/-103/-107/-201 and D407-667-105 crosstubes, the outward face of the support tabs should be 13.08" (332mm) from the crosstube center. For D206-667-203/-207 crosstubes, the outward face of the support tabs should be 10.03" (255mm) from the crosstube center. Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.3.9) of ICA-D206-667.
- 32.4.2 If present, remove any paint/primer on bottom of supports. Abrade mating surfaces of support and crosstube with 400-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Ensure a layer of 3M Scotch-Weld 2216 B/A Epoxy Adhesive is on the bottom of the support. If required, either apply or touch-up support to have a 0.03" to 0.05" thick layer of adhesive over the entire mating surface. Allow supports to cure for 24 hours.
- 32.4.4 Abrade mating surfaces of support (after cure) and crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.5 Apply a 0.04" to 0.07" thick layer of Proseal 890 Class B or AMS-S-8802 Class B sealant underneath applicable support and install support.
- 32.4.6 Install the clamps opposite to crosstube support as shown in Figures 32-4 to 32-8 of ICA-D206-667. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 80-100 in-lb (9.0-11.3 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps than those listed in ICA-D206-667, ensure that after torquing the clamps per this instruction, the nuts are in safety but not bottomed out.
- 32.4.7 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.07.20
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	CP	11.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9565	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION CHANGE	NTS
DATE	11.07.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

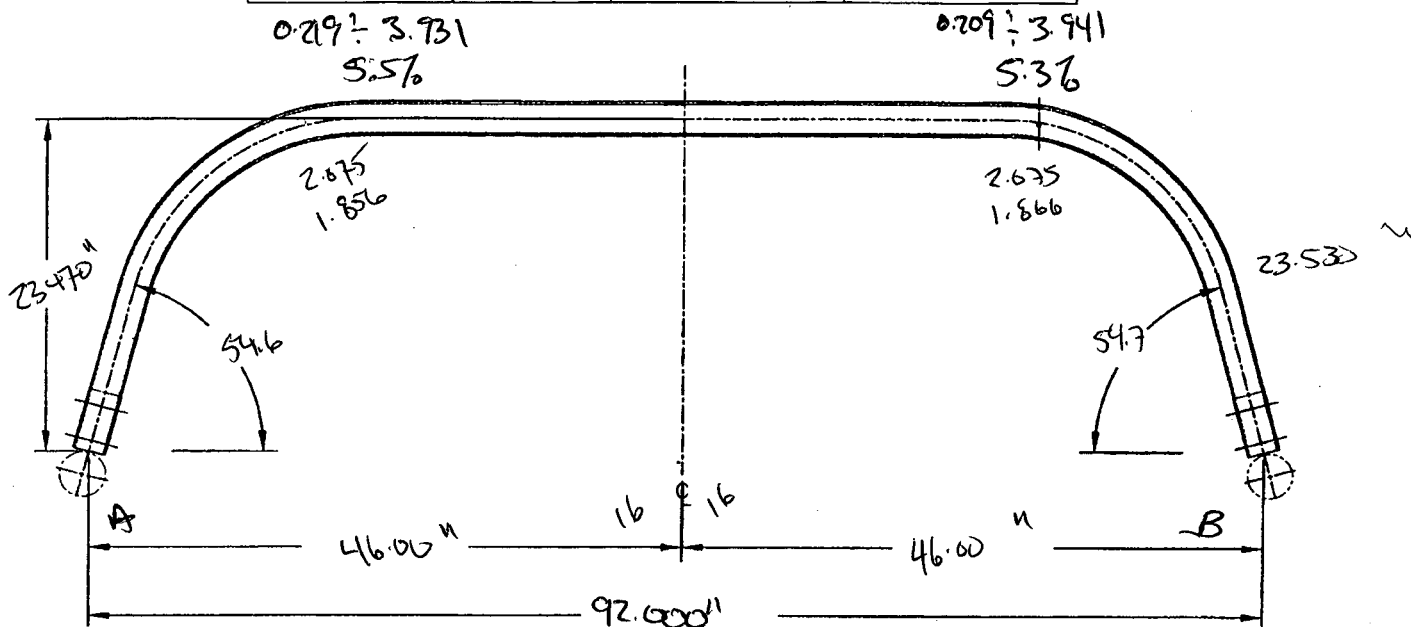
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82728
Description: Crosstube High Fwd (407)		Part Number:	D407-667-105
Inspection Dwg: D407-667-145 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	23.41	23.67
1/2 Span	45.81	46.07
Angle	54	56
Total Span	91.63	92.13



Comments
Side A = 5.5% crushing @ 16 passes.
Side B = 5.3% crushing @ 16 passes.

QC15 Inspection	
Date	17/01/26

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.12	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W 10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82728 MCT

12/04/26

DEO ATTACHED

ECW #11-615
11.07.26

UNDER REVIEW

RELEASED
08/11/26

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D407-667-145	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

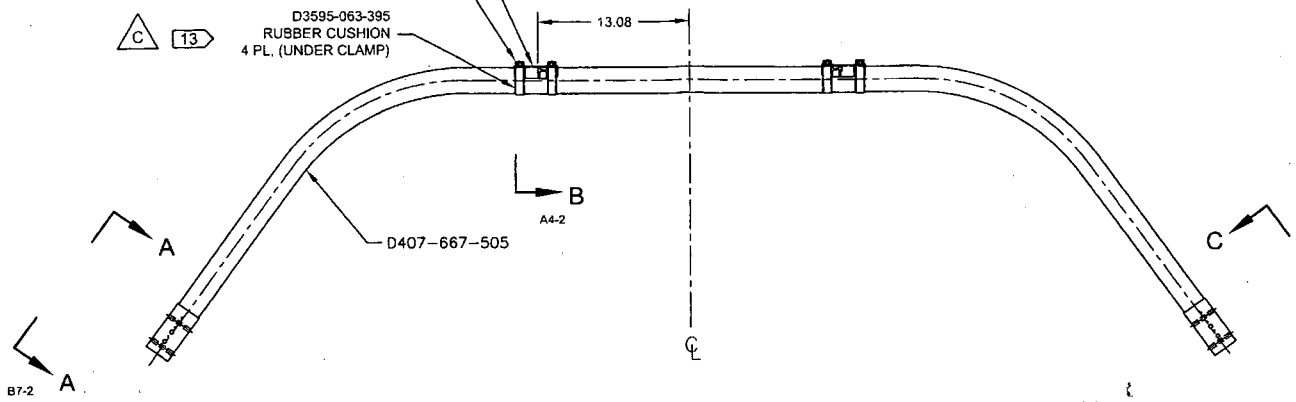
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

02728

- 12 D2891-1 SUPPORT 2 PL
- 15 MS21920-20 CLAMP 4 PL
- 13 D3595-063-395 RUBBER CUSHION 4 PL (UNDER CLAMP)



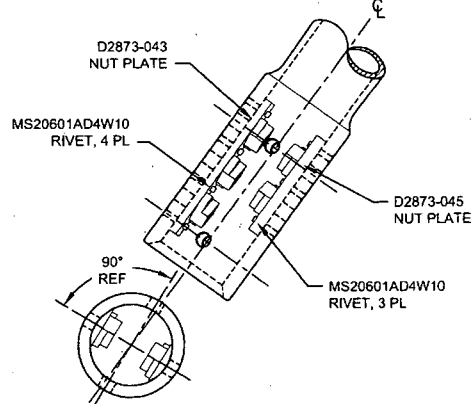
ECW #11.615
11.07.26

UNDER REVIEW

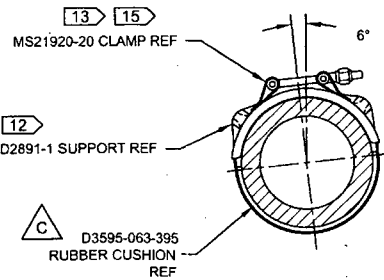
RELEASE
08/11/2006

DEO ATTACHED

D407-667-145
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



VIEW A-A:
CUFF DETAIL
SCALE 4X



SECTION B-B
SCALE 5X

VIEW C-C:
CUFF DETAIL
SCALE 4X

DESIGN	47	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D407-667-145	REV. C SHEET 2 OF 4
CHECKED	47	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
MFG. APPR.	47	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
APPROVED	47	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	47	DATE 08.11.06	

8 7 6 5 4 3 2 1

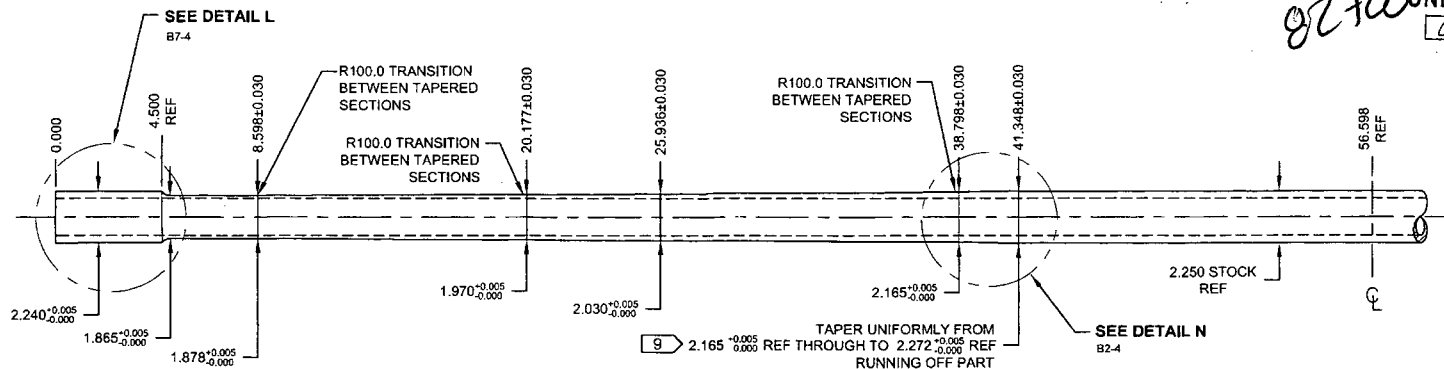
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

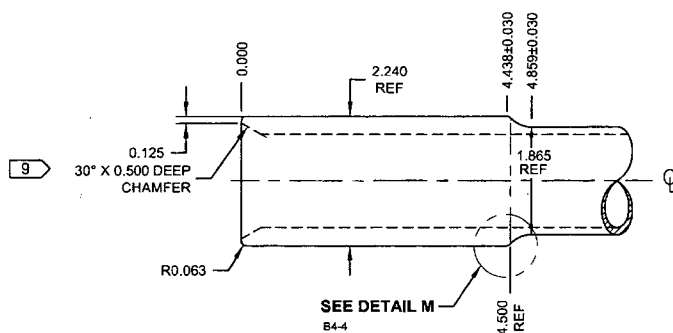
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

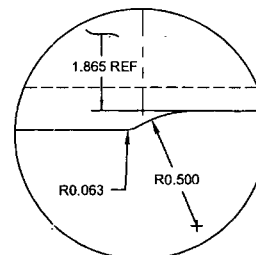
NOTE: Date & initial all entries



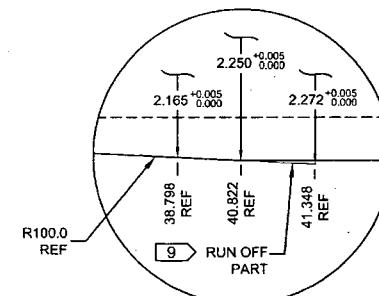
C TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

DEO ATTACHED
RELEASED
08/11/08

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D407-667-145	SHEET 4 OF 4
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D407-667-145	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-145-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED ASS	MFG. APPR. 188	APPROVED WD		DE APPR. H		
DATE 11.07.15	DATE 11.07.22	DATE 11.07.22	DATE 11/07/22		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -145	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 05648

PAGE 1 OF 1

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

PO/VO NO.

WORK LOCATION

ACCEPTANCE STD.

TIME

AM

PM

REV./DATE

2005

JOB DESCRIPTION

PROCEDURE NO. LT-002 REV./DATE 2009

TECHNIQUE NO. LT-002 REV./DATE 2009

PART NO.

MATERIAL

THICKNESS

SCOPE

TEST DETAILS

METHOD

☒ FLUORESCENT☐ VISIBLE☒ WATER WASH☐ SOLVENT REMOVABLE☐ POST EMULSIFIED

FAMILY BRAND

MAGNAFLUX

BLACK LIGHT S/N 13798

OUTPUT > 1000 μ W/cm²☐ AMBIENT < 2 fc

PENETRANT

ZK-67

MINIMUM DWELL TIME

45

MIN.

LIGHTING EQUIP.

☐ FLASHLIGHT☐ TROUBLELIGHT☐ OUTPUT > 100 fc @ SURFACE

PENETRANT REMOVER

H2O

MINIMUM DRY TIME

> 10

MIN.

OTHER

DEVELOPER

SKD-52

MINIMUM DWELL TIME

30

MIN.

LIGHT METER S/N

1098866

CAL DUE DATE 01/28/12

DEVELOPER TYPE

☒ NON AQUEOUS☐ AQUEOUS☐ DRY

TEST SURFACE

SURFACE CONDITION

☐ AS GROUND☐ AS WELDED☐ MACHINED☐ SHOT BLASTED☒ CLEAN BARE METAL

SURFACE TEMPERATURE

☐ < -4°C/ 20°F☐ -4°C/ 20°F TO 10°C/ 50°F☒ 10°C/ 50°F TO 52°C/ 125°F☐ > 52°C/ 125°F

RESULTS-

☐ METRIC ☐ IMPERIAL

1	ATTACH. BIRD W.O.I.D	83249	✓
2	TUBE W.O.I.D	83735	✓
3	CROSSTUBE FWD W.O.I.D	83703	✓
4	" FWD W.O.I.D	83702	✓
5	" FWD W.O.I.D	83729	✓
6	" FWD W.O.I.D	83728	✓
7	" AFT W.O.I.D	83184	✓
8	" AFT W.O.I.D	83185	✓
9	" AFT W.O.I.D	82114	✓
10	" AFT W.O.I.D	82113	✓

ITEM ID	D4137-1 REV'D PRELIM
ITEM ID	D4138-1 REV'D PRELIM
ITEM ID	D206-667-101
ITEM ID	D206-667-101
ITEM ID	D407-667-105
ITEM ID	D407-667-105
ITEM ID	D412-664-203
ITEM ID	D412-664-203
ITEM ID	D407-667-205

NO RELEVANT INDICATION WAS DETECTED AS PER

APPLICABLE STANDARD

12.05.04

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE

TECHNICIAN (SIGNATURE):

NAME (PRINT):

Matthew Murdoch

PRINT

Matthew Murdoch

SIGNATURE

YES (BOSIER)

1ST TECHNICIAN

CGSB LEVEL

2

SNT LEVEL

2

CGSB REG. NO.

3044

CGSB LEVEL

—

SNT LEVEL

—

CGSB REG. NO.

—

DTR # E84955

REPORT

REVIEWED BY:

NAME

INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY



Daily Time Report

E-84955

Form dated September 2010

Client: JOINT AEROSPACE
 Contact: LYNDA, CHASTAC, MATT
 Location: 1370 ABERDEEN ST., HAWKSBURY, ON
 Description: PT WET FLUO
 Report #s: 7-05648

Job #: _____
 Day: Sun Mon Tues
 P.O. #: _____
 Vehicle #: 636

Date: MAY-04-2012
 Wed Thurs Fri Sat
 W.O #: 188-12-00121
 Camera #: _____

Name	Specialist	Tech.	CEDO	Assistant	Start Time	Total Hours			KM	LOA (✓) ONLY	OTM (✓) ONLY	Labour Agreement (if known) or type of work	TLD No.	Daily DRD Readings
						Travel	Worked	SP						
✓ <u>VERDE, JESSE</u>	✓				6:00	AM				<input type="checkbox"/>	<input type="checkbox"/>		854896	—
						PM	3 1/2	3 1/2	230	<input type="checkbox"/>	<input type="checkbox"/>			
						AM				<input type="checkbox"/>	<input type="checkbox"/>			
						PM				<input type="checkbox"/>	<input type="checkbox"/>			
						AM				<input type="checkbox"/>	<input type="checkbox"/>			
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						AM				<input type="checkbox"/>	<input type="checkbox"/>			
						PM				<input type="checkbox"/>	<input type="checkbox"/>			

WELD INSPECTION SUMMARY

Weld Diameter										Long Seam					Circ. Seam				
Schedule/Thickness										Thickness					Thickness				
Quantity										Lineal Ft.					Lineal Ft.				

Film: _____ Pcs. 2 1/4 x 17"
 _____ Pcs. 3 1/2 x 17"
 _____ Pcs. 4 1/2 x 17"
 _____ Pcs. 14" x 17"
 _____ Pcs. _____
 Consumables (cans / litres): _____ UT 3 PT _____ MT

Re-billable expenses: _____
 Equipment charges: _____
 Client Representative: Matt Murchak

ACUREN 1-877-299-2857

Cambridge, ON (519) 622-3112 • Fax (519) 622-1326
 Cantley, QC (819) 360-0685 • Fax (819) 327-3513
 Cornwall, ON (613) 931-1261 • Fax (613) 931-2777
 Gaspé, QC (418) 392-3618 • Fax (418) 392-4114
 Halifax, NS (902) 443-4448 • Fax (902) 445-5090
 Jonquiere, QC (418) 542-8273 • Fax (418) 542-5494
 Mississauga, ON (905) 673-9899 • Fax (905) 673-8394
 Montreal, QC (450) 492-3399 • Fax (450) 492-5682
 North Bay, ON (705) 840-8107 • Fax (705) 476-6683
 Oakville, ON (905) 825-8595 • Fax (905) 825-8598
 Pickering, ON (905) 839-0015 • Fax (905) 839-5641
 Port Elgin, ON (519) 389-6797 • Fax (519) 389-6799
 St. John's, NL (709) 753-2100 • Fax (709) 753-7011
 Samia, ON (519) 336-3021 • Fax (519) 336-8220
 Sherbrooke, QC (819) 620-5456 • Fax (819) 346-6828
 Sudbury, ON (705) 522-1849 • Fax (705) 522-9926
 Thunder Bay, ON (807) 475-4240 • Fax (807) 577-2017
 Timmins, ON (705) 365-8313 • Fax (705) 267-2855
 Val D'Or, QC (819) 856-6789 • Fax (819) 825-9564

NOTES:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.05.03	200/ 210	Apply clear coat to entire of outside surface of cross tube, except mask off area of support.				JP 12.05.04 PS/10/12	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries